



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-1
Job Sheet 179294



Part No: D2933-1

Job Qty: 4 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		6/29/18	0.00	0.00	Start Up Machining-1		SBL 18/08/05
100	CNC Vertical Machining	4 pcs		6/29/18	0.40	5.92	HAAS1-2		SBL 18/08/05
110	Mill Conv	4 pcs		6/29/18	0.00	0.25	Mill Conv 1		SBL 18/08/05
120	QC	4 pcs		6/29/18	0.00	0.00	QC1		SBL 18/08/05
130	QC	4 pcs		6/29/18	0.00	0.00	QC8 Machining-1		2mm L 18/08/09
140	HandFinish	4 pcs		6/29/18	0.00	0.19	HandFinish1		D.R 18/08/09
150	Powdercoat	4 pcs		6/29/18	0.00	0.14	Powdercoat1		el 18/08-10
160	QC	4 pcs		6/29/18	0.00	0.00	QC3		38
170	Packaging	4 pcs		6/29/18	0.00	0.00	Packaging3-1	5/376	AUG 2 3 2018
180	QC21-SA	4 Ea		6/29/18	0.00	0.00	QC21		AUG 2 4 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & Descriptions: attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA020.

150 - START TIME: 10:40am 10:30am 3200F

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Container No: S099254



Part: D2933-1

Job No: 179294

Serial No/Batch: S099254

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/03/18

ALL
BE
STC

DART AEROSPACE LTD		Work Order: 179294
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

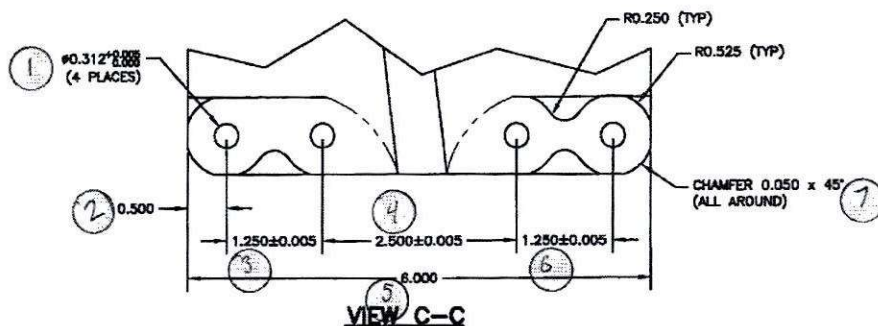
☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.126	.125	.125	.126	
B	0.100	0.140		.124	.123	.122	.124	
C	0.100	0.140		.110	.110	.110	.111	
D	0.210	0.230		.223	.222	.223	.223	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.510	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.257	.257	.257	.257	
L	0.312	0.317		.312	.312	.312	.312	
M	0.235	0.240		.239	.239	.239	.239	
N	0.100	0.140		.130	.130	.124	.123	
O	0.540	0.560		.550	.549	.549	.550	
P	0.490	0.510		.498	.498	.499	.499	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.493	2.490	2.490	2.492	
S	0.240	0.270		.250	.250	.255	.255	
T	0.100	0.180		.130	.140	.135	.140	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.125	1.145		1.135	1.135	1.135	1.135	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								

DAS Accept/Reject

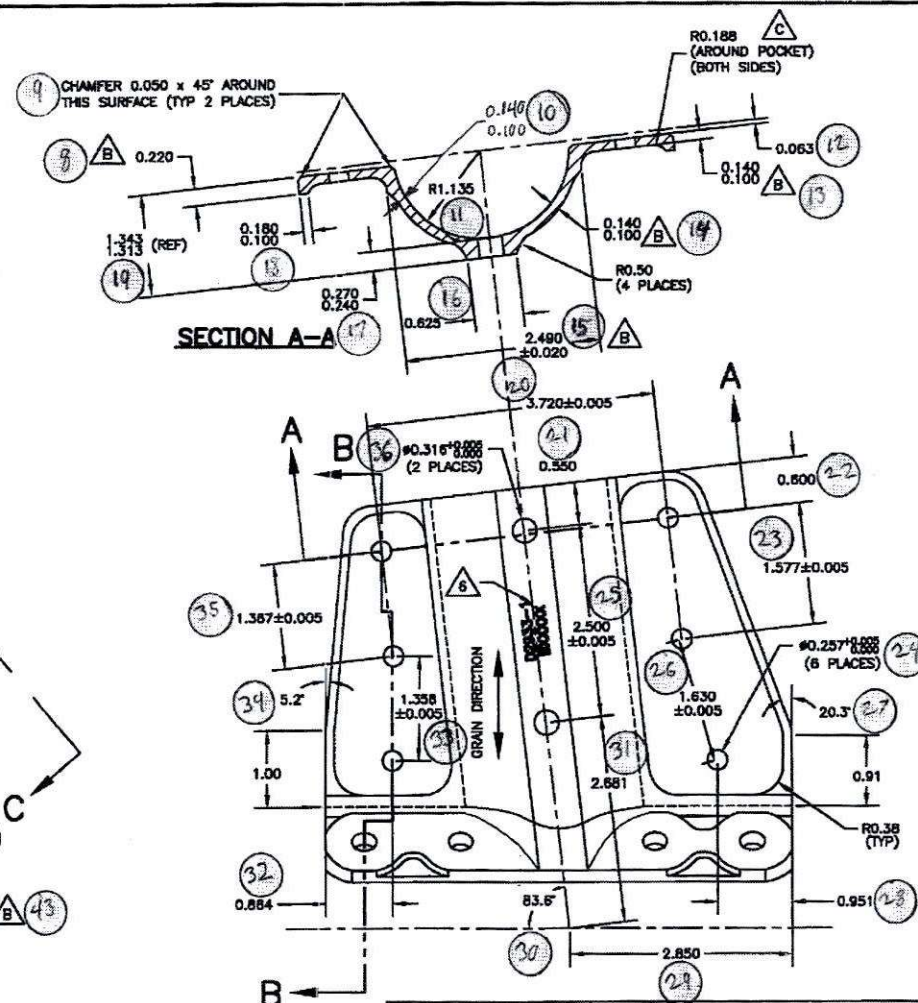
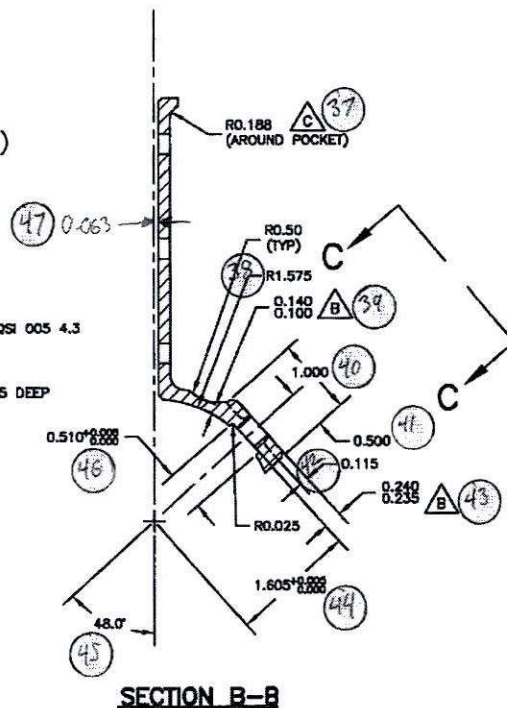
Measured by: 57 18/08/04	Date:
Audited by: [Signature]	Date: 18/08/04
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



D2933-1 LH SADDLE (SHOWN)
~~D2933-2 RH SADDLE (OPPOSITE)~~

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.3.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE INSIDE
		DART AEROSPACE USA, INC. BELLINGHAM, WA
		REV. C SHEET 1 OF 1
		SCALE 2:3

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RELEASED
07.02.12